

Date:
User:Thursday, 3/8/2007 1:21:05 PM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE		
Job Number	: 31136					
Estimate Number	: 12786					
P.O. Number	: N/A		Part Number	: D35645		
This Issue	3/8/2007	S.O. No. : N/A	Drawing Number	: D3564 REV A		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: A		
Previous Run	: N/A		Material	: N/A		
Written By			Due Date	: 3/15/2007 Qty: 6 Um: Each		
Checked & Approved By						
Comment	: Est Rev:A New Issue 07-03-08 ec					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 1.1099 sf(s)/Unit Total : 6.6591 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: M7106 SAO 07/03/11		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: A Prog Rev: A		
2-Deburr if necessary SAO 07/03/11		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAO 07/03/11		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK SAO 07/03/12 (6)		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT and DT		

Form Joggle as per Dwg D3564 on brake using Jig DT

SB 07/03/13 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:21:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31136

Part Number: D35645

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

3/03/13 (6)

7.0 POWDER COATING

POWDER COATING



m101601

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

3/03/14 (6)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

3/03/15 (6)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

3/03/15 (6)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

3/03/15 (6)

Job Completion



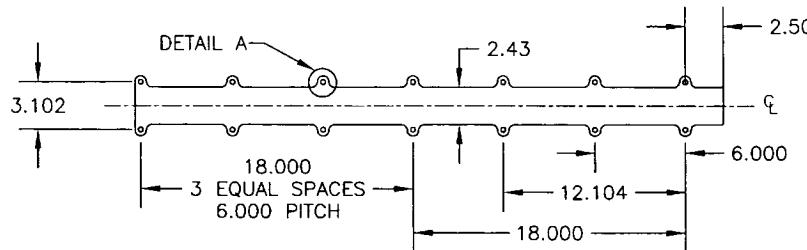
3/03/15 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

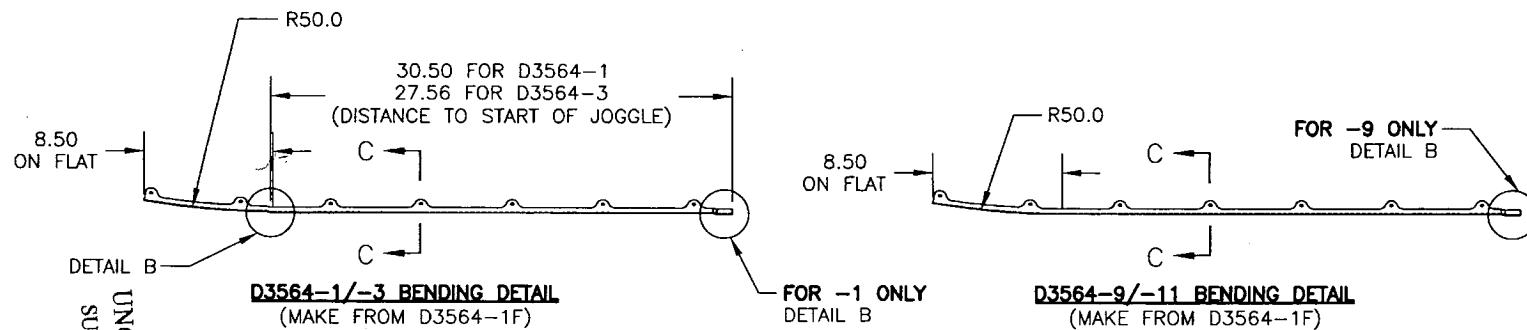
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3564-1F FLAT PATTERN

SHOP COPY
RETURNED
BY ENGINEER
UNCONTROLLED COPY
SUPPLY TO AGENCIES
WITHOUT NOTICE
WHICH ORDER
NO. _____



- FOR -1 ONLY
DETAIL B

D3564-9/-11 BENDING DETAILS
(MAKE FROM D3564-1E)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31136

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

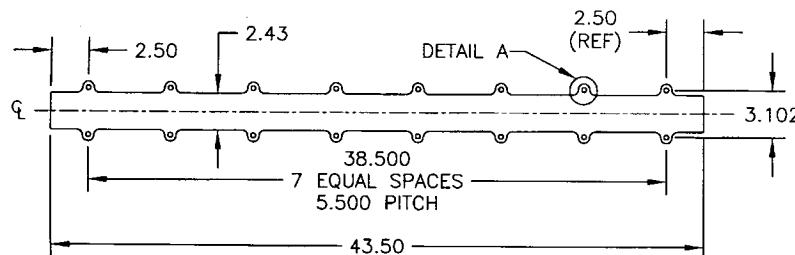
D3564-1/-3/-9/-11 WELDING DETAIL

D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

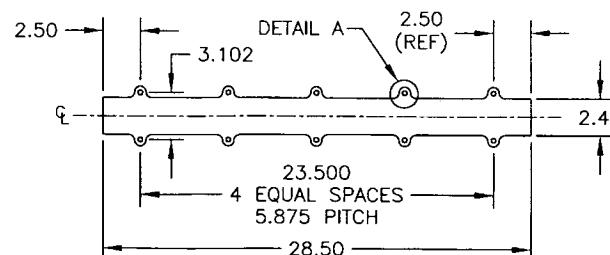
- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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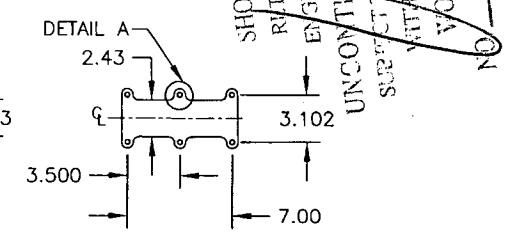
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. A D3564 SHEET 1 OF 2
DATE	TITLE SCAL	
06.12.18	WEARSHOE 1:1	



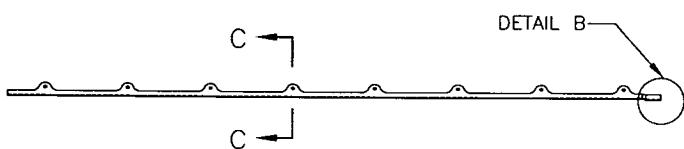
D3564-5F FLAT PATTERN



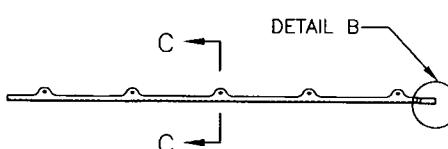
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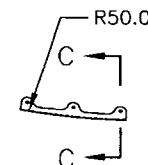
D3564-13F FLAT PATTERN



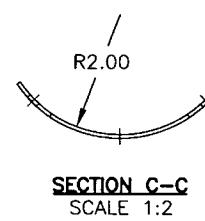
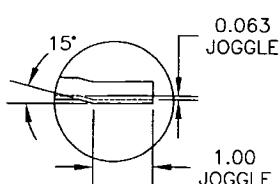
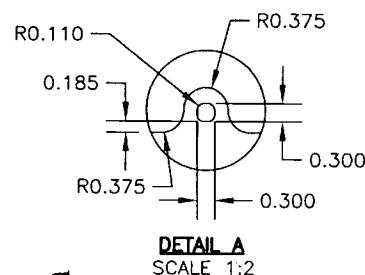
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



UNRELEASED
07/02/28

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DESIGN PH
CHECKED PH
APPROVED PH
DATE 06.12.18

DRAWN BY PH
DRAWING NO. D3564
TITLE WEARSHOE

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA
REV. A
SHEET 2 OF 2
SCALE 1:8

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
NO. 31136
WORK ORDER
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

DART AEROSPACE LTD

Work Order: 31136

Description: Wear shoe

Part Number: D3564-5

Inspection Dwg: A Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by: SAD
Date: 07/03/11

Audited by:	<i>RG</i>
Date:	07.03.11

Prototype Approval:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	